

Date: Friday, 09/01/2009 2:39:52 PM
 User: Linda Lacelle

Gray
Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM ASSEMBLY
 Job Number : 44542
 Estimate Number : 13294
 P.O. Number :
 This Issue : 09/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3696041
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3696 REVB PRELIM
 Previous Run : 40741 Project Number : N/A
 Material :
 Due Date : 30/01/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-05-01 JLM Verified By:EC
 Est Rev:B 08-07-22 redesign part (prelim) DD verified by:EC

POSITIVE
 RECALL

Additional Product

PRELIMINARY ISSUE

Job Number:



09.01.09 per
 ECN#09-502P

Seq. #: Machine Or Operation: Description :

1.0 M7075T6B1000X1000 7075 T6 BAR 1.00 x1.00



Comment: Qty.: 1.5330 f(s)/Unit Total : 6.1320 f(s)

7075 T6 BAR1"x1"

Batch: M107984

J.F. 09/01/11

(4)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 17.750" long

J.F. 09/01/11

(4)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Mill as per dwg D3696

2-Deburr as per dwg D3696

J.F. 09/01/11

(4)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/11

(4)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 09.01.13 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/01/2009 2:39:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM ASSEMBLY

Job Number: 44542

Part Number: D3696041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

090114

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- mask prior to painting as per dwg (see note 8)

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

3:45

OVEN TEMPERATURE:

320°

FINISH TIME:

4:15

FL 09/01/19

4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M 09.01.20

9.0

D37991

Oilite Bronze Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Oilite Bronze Bushing

Batch: 44539

WKF 09-01-20

10.0

D38013

Hand Retractable Spring Plunger



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Hand Retractable Spring Plunger

Batch:

40737

SS 09/01/20

11.0

MS21209C8 20

Heli Coil Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Heli Coil Insert

Batch:

MP08066

SS 09/01/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/01/2009 2:39:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM ASSEMBLY

Job Number: 44542

Part Number: D3696041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Helicoil

2-Press Bushing

3-Install Plunger

FF

09/01/21

(4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

09.02.20 (4)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 254 MF 09-02-20

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



MF 09-01-21

POSITIVE RECALL

EFFECTIVE 09/01/21 AUTH h

RELEASED h DATE 09.02.17

DART AEROSPACE LTD		Work Order: 44542
Description: Arm Assembly		Part Number: 03646-1
Inspection Dwg: 03646 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

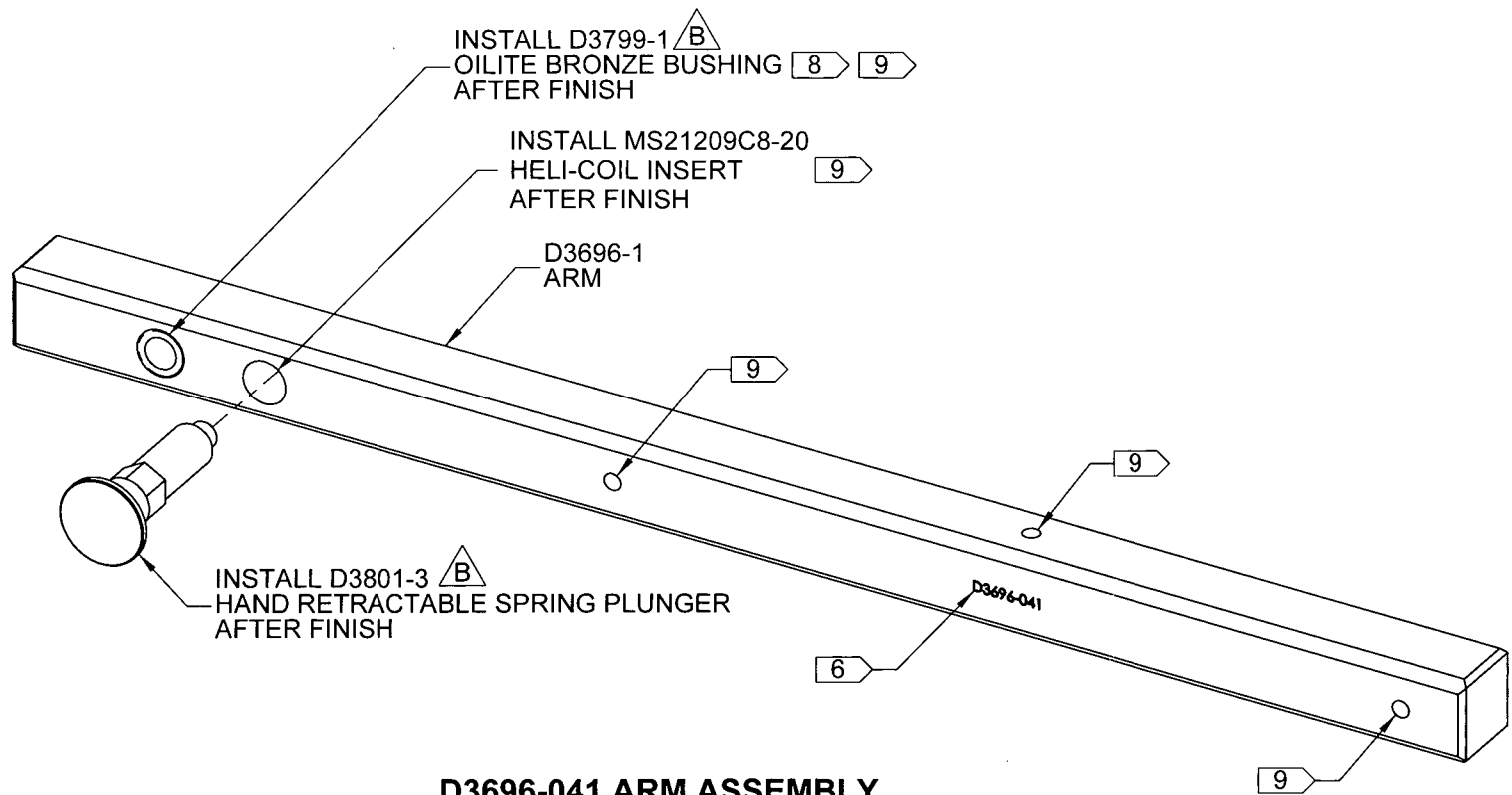
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .201"	+ .005"	Ø .204"	✓			
Ø .500"	+ .006"	.499"	✓			
.300"	± .010"	.301"	✓			
.495"	± .010"	.493"	✓			
5.500"	± .010"	5.499"	✓			
.13"	± .030"	.130"	✓			
.990"	+ .000"	.987"	✓			
1.000"	± .010"	1.001"	✓			
.500"	± .010"	.501"	✓			
1.800"	± .010"	1.800"	✓			
1.250"	± .010"	1.250"	✓			
9.500"	± .010"	9.500"	✓			
.750"	± .010"	.751"	✓			
.060x45°	± .030"	.065"	✓			
Ø .566"	+ .001"	.566"	✓			
1/2-13unc	Helicoil	1/2-13	✓			
17.50"	± .030"	17.500"	✓			

Measured by: J.F.	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/01/11	Date: 09.01.14	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

QTY -041	P/N	DESCRIPTION
X	D3696-041	ARM ASSEMBLY
1	D3696-1	ARM
1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)
1	D3799-1	OILITE BRONZE BUSHING
1	D3801-3	HAND RETRACTABLE SPRING PLUNGER



D3696-041 ARM ASSEMBLY

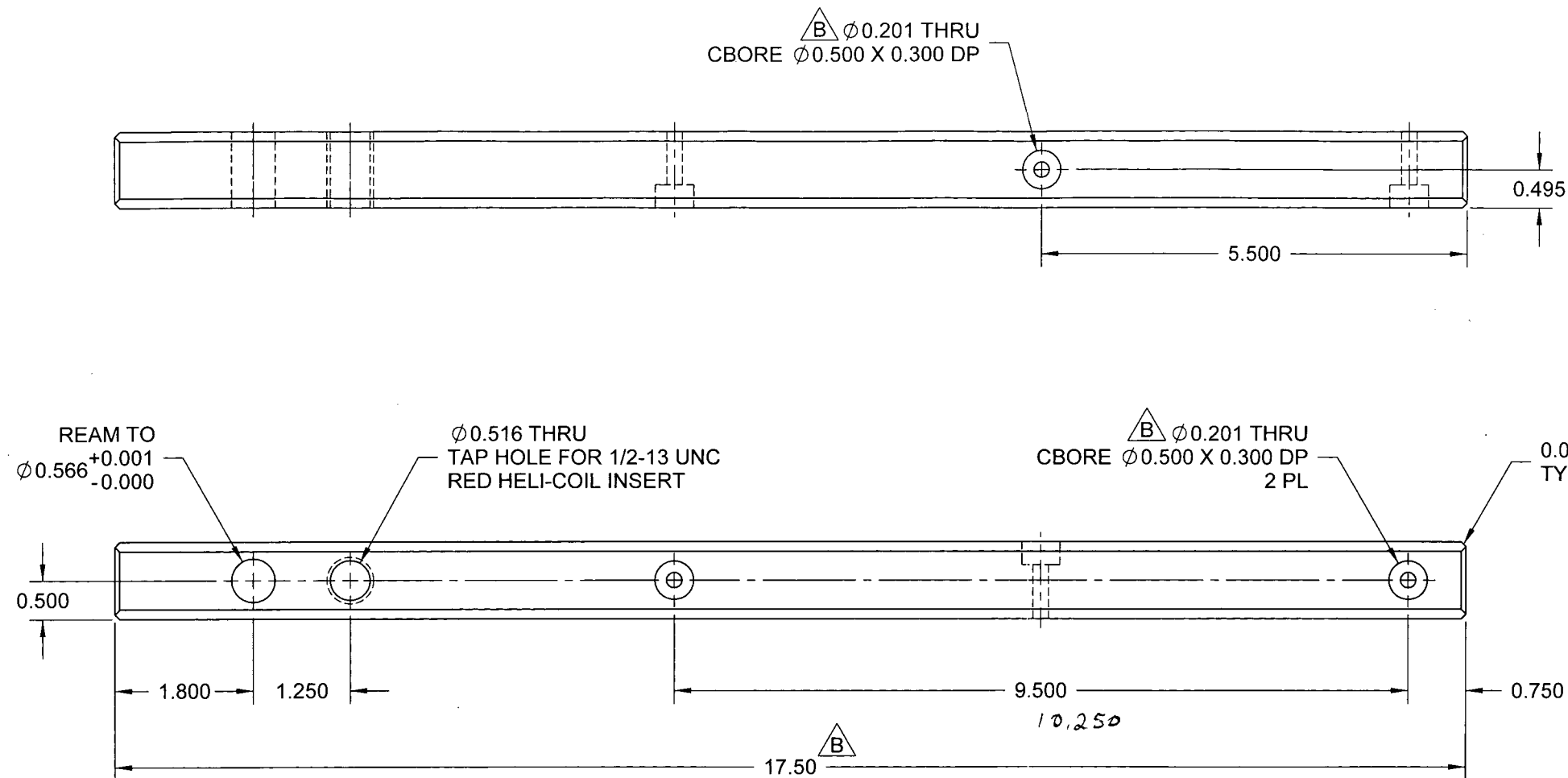
D3696-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.68 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

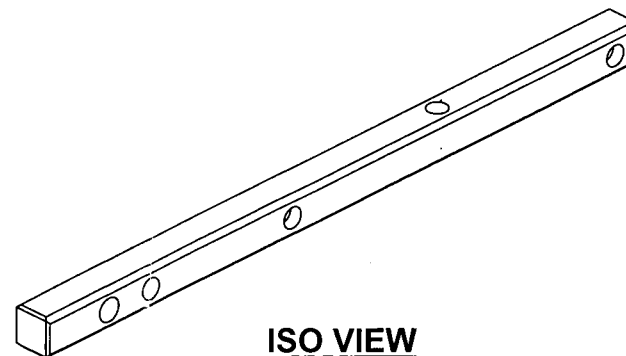
PRELIMINARY ISSUE

09.01.09
Per enw #09-0020

B	P/N D3799-1 WAS BNT-137 (ZN D6-1); P/N D3801-3 WAS PRT-12 (ZN C7-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS; ADDED $\phi 0.201$ HOLE AND CBORE (ZN C6-2 AND D5-2); 17.50 WAS 19.50 (ZN B5-2); 1.000 WAS 0.990 $+0.000/-0.010$ (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3696	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM ASSEMBLY	NTS
DATE	08.07.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3696-1 ARM



D3696-1 NOTES:

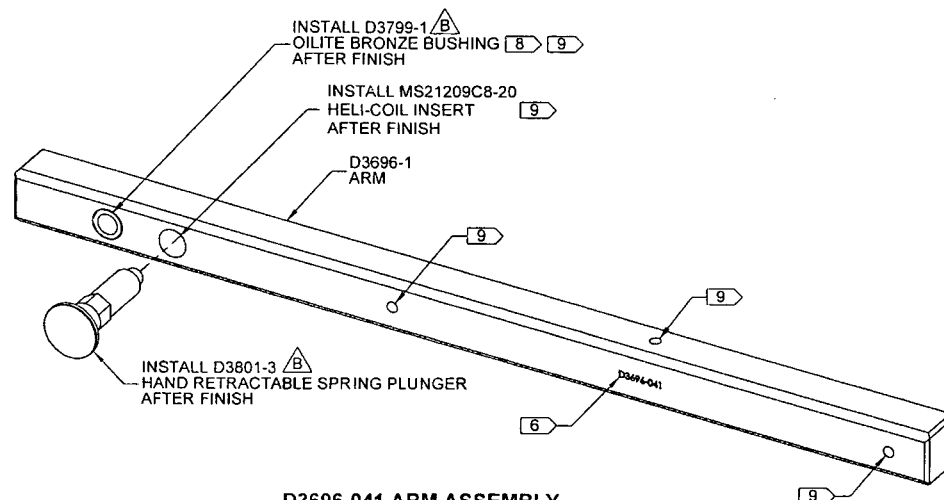
- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11
(REF. DART SPEC. M7075T6B)
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.62 lbs

PRELIMINARY ISSUE

445212
C.A.C.A.
POL. BCN #C9-502P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3696	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM ASSEMBLY	NTS
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QTY -041	P/N	DESCRIPTION
X	D3696-041	ARM ASSEMBLY
1	D3696-1	ARM
1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)
1	D3799-1	OILITE BRONZE BUSHING
1	D3801-3	HAND RETRACTABLE SPRING PLUNGER



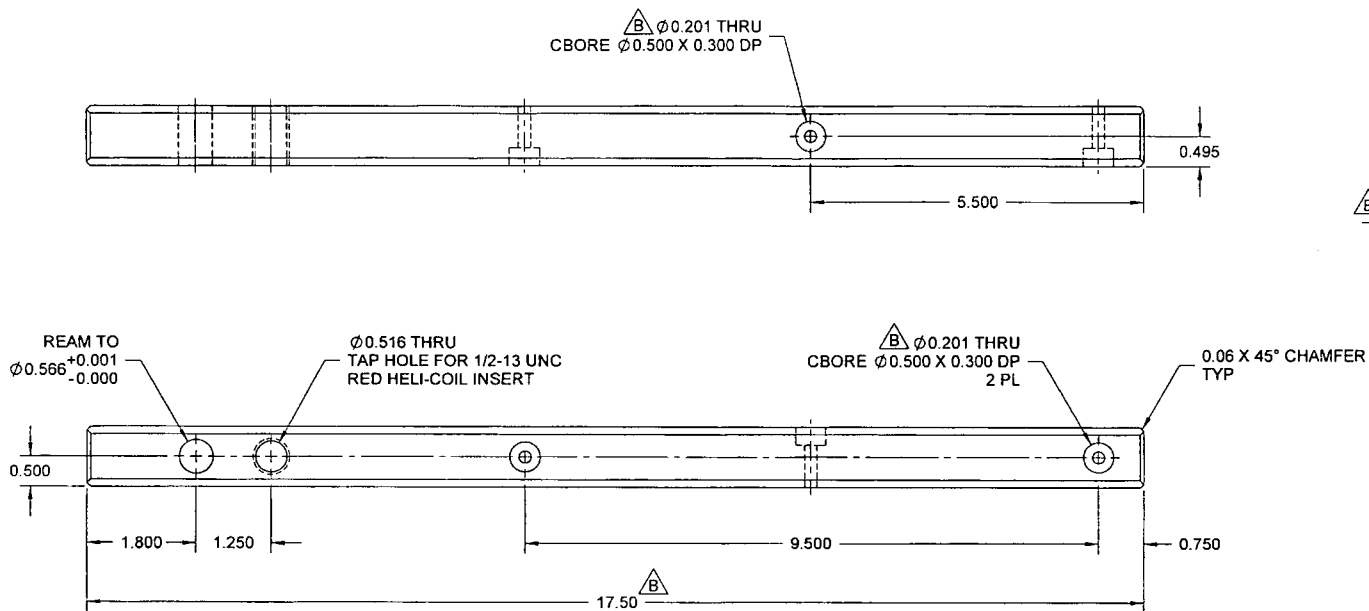
D3696-041 ARM ASSEMBLY

RELEASED
09/03/15 MB

D3696-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.68 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

B	P/N D3799-1 WAS BNT-137 (ZN D6-1); P/N D3801-3 WAS PRT-12 (ZN C7-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS; ADDED Ø0.201 HOLE AND ØBORE (ZN C6-2 AND D5-2); 17.50 WAS 19.50 (ZN B5-2); 1.000 WAS 0.990 +0.000/-0.010 (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3696	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM ASSEMBLY	NTS
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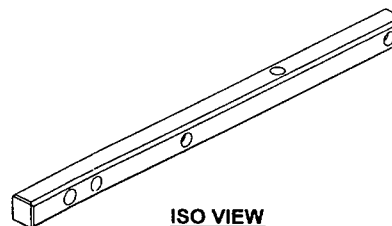
D3696-1 ARM

275772

RELEASED
09/05/02 M/D

D3696-1 NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11
(REF. DART SPEC. M7075T6B)
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.62 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3696	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM ASSEMBLY	NTS
DATE	08.07.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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